

38

Date: Tuesday, 8/28/2007 3:15:52 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 34288		
Estimate Number	: 12664		
P.O. Number	: N/A	Part Number	: D206559011
This Issue	: 8/28/2007 S.O. No. : N/A	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 32977	Material	: N/A
Written By	:	Due Date	: 9/22/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>JA 07.08.28</u>		
Comment	: Est Rev: C 04.02.17 Blank size changed KJ/JLM Est Rev: D 07-01-02 Was K10007 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG005

07.09.05

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.5491 sf(s)/Unit Total : 45.4913 sf(s)

blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3

Material: Black UHMW 1"

(MUHMWB10)

Batch: M103315

NOT ENOUGH MATERIAL IN THE COMPUTER.

07/09/12

16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

07/09/12

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/09/12

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 8/28/2007 3:15:52 PM  
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Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 02-01-12

(10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 16.6600 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

B30812

W

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2435(ref only) Bearpaw

B25223

16 X

B30875

64 X

B34288

W

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp

B30631

W

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

B25372

16 X

B30382

64 X

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X16")

Job Number: 34288

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M104072

Be

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Batch:

M102280

Be

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M104746

Be

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M104248

Be

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M103947 4X

M105516 16X

1 Paperwork package

Be 7/9/13

(10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Be 07-13

(10 Kits)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 8/19/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

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Job Number: 34288

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: \_\_\_\_\_

REV: A

07/19/30

18.0

QC21

FINAL INSPECTION W/O RELEASE



(K)

Comment: FINAL INSPECTION W/O RELEASE

08/09/14

Job Completion



11 8-09-14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

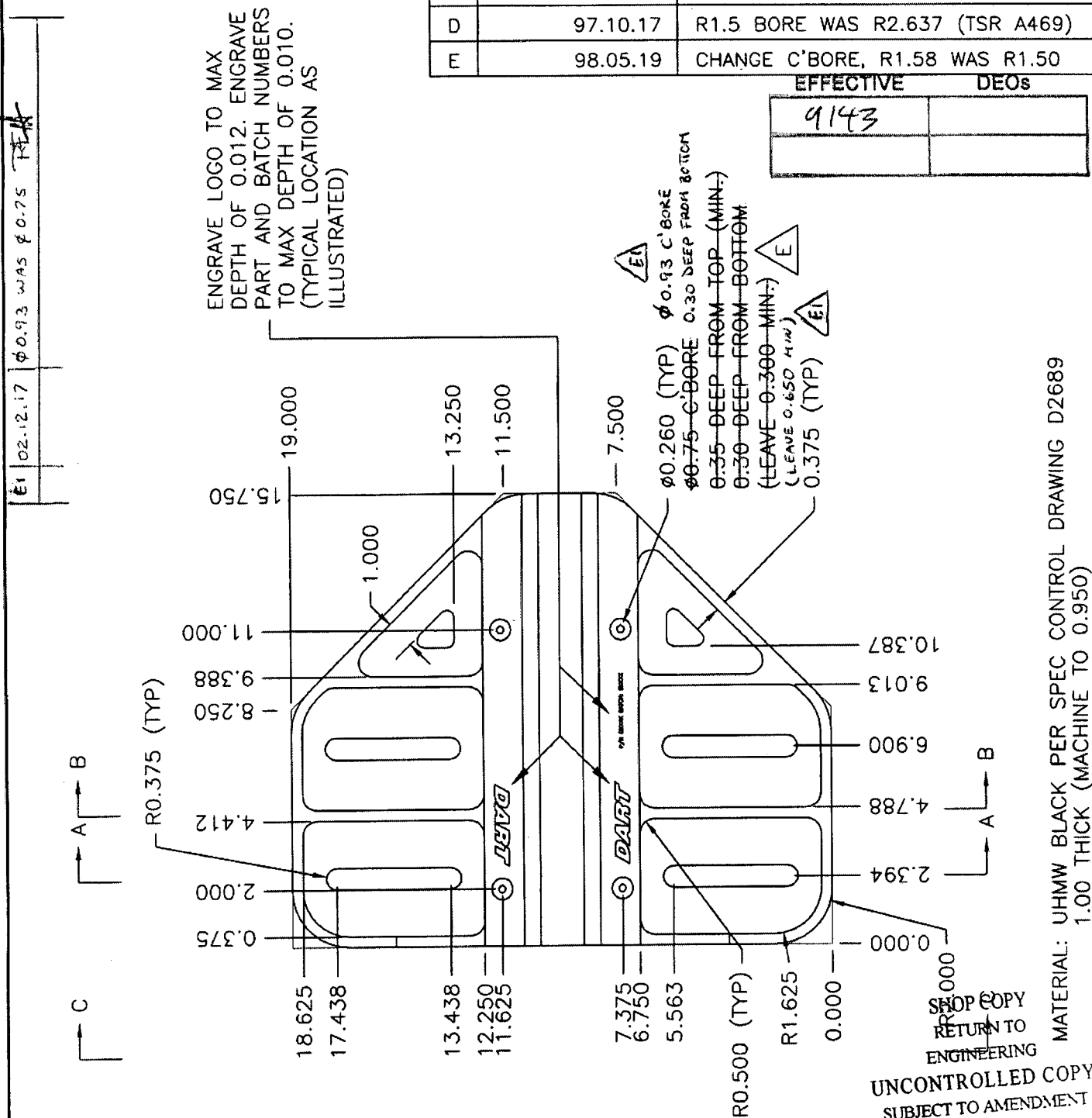




DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>		APPROVED <i>OS</i>		DRAWING NO. REV. E D2435 SHEET 1 OF 2	
DATE 98.05.19		TITLE BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

## EFFECTIVE DEOS

9143



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

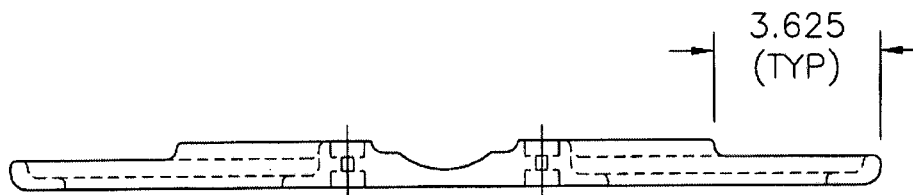
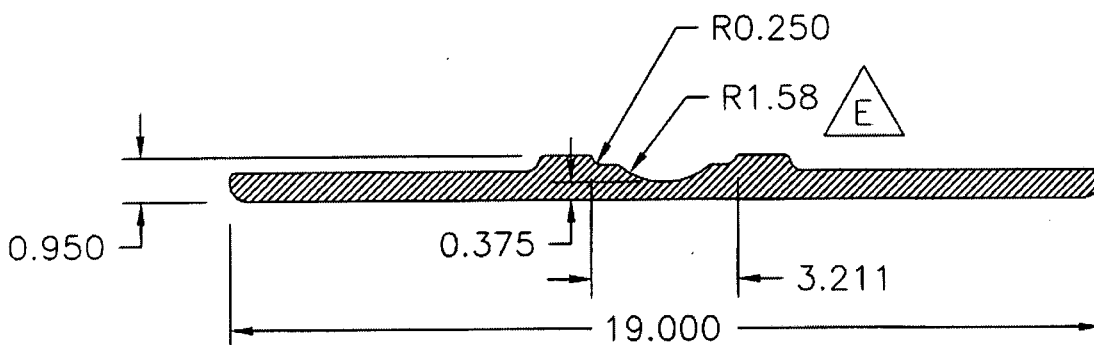
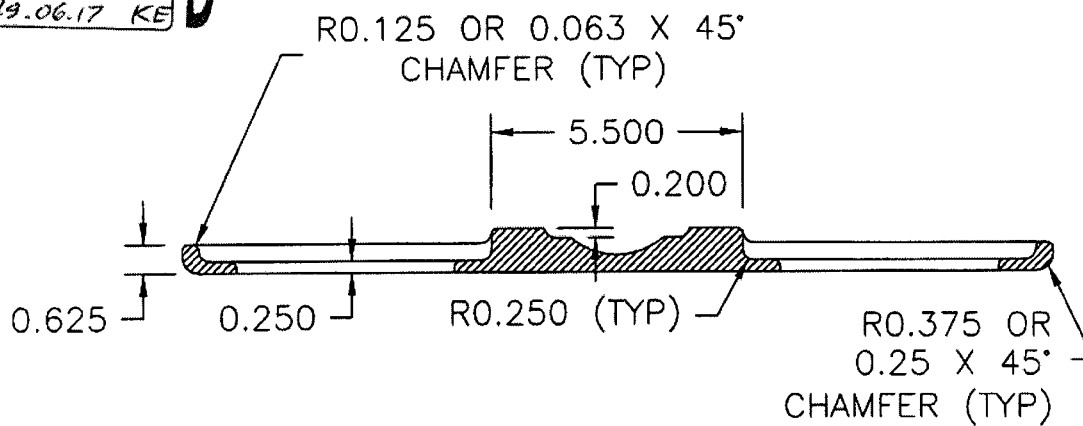
WORK ORDER  
NO. 34288

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24288

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Bearpaw</b>		<b>Part Number:</b>	<b>D2435</b>
<b>Inspection Dwg: D2435      Rev: E1</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
         
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053 x 45°	—			
B	5.500	+/-0.030	5.503	—			
C	0.200	+/-0.030	0.200	—			
D	R0.250	+/-0.030	R0.250	—			
E	0.250	+/-0.010	0.257	—			
F	0.625	+/-0.030	0.613	—			
G	0.25 x 45°	+/-0.030	0.233 x 45°	—			
H	0.375	+/-0.010	0.382	—			
I	19.000	+/-0.030	19.000	—			
J	0.950	+0.030/-0.010	0.948	—			
K	Ø0.260	+0.005/-0.000	Ø0.260	—			
L	Ø0.930	+/-0.030	Ø0.928	—			
M	0.30	+0.030/-0.000	0.310	—			
N	0.375	+/-0.030	0.385	—			
O	7.375	+/-0.030	7.375	—			
P	4.250	+/-0.010	4.250	—			
Q	2.000	+/-0.030	2.000	—			
R	9.000	+/-0.010	9.000	—			
S	15.750	+/-0.030	15.750	—			

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/09/11	<b>Date:</b>	07-09-11	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O K10007	KJ/RF	

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-559

Job Number : 36674

Estimate Number : 10804

P.O. Number : N/A

This Issue : 09/01/2008

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : MACHINED PARTS

Previous Run : 00015

Part Number : Z\_CUSTOM

Drawing Number : ECN1101

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 16/01/2008

Qty: 1 Um: Each

Written By : W  
Checked & Approved By : W  
Comment :

### Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REMOVE FROM STOCK:

D206-559-011

B34288 (10x) B30377 (x2) B30800 (x1) B32977 (x5)

D206-559-013

B32768 (9x) B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

B25291 (x3) B34856 (x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO  
PER ECN 1101

RETURN TO STK

8/1/10 SD 45x AS

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/11

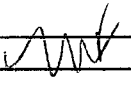
Job Completion



W 28-01-11

Date: Thursday, 01/05/2008 1:56:32 PM  
User: Melanie Fauteux

# **Process Sheet**

<b>Customer</b> :	CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> :	D206559011
<b>Job Number</b> :	38954		
<b>Estimate Number</b> :	10804		
<b>P.O. Number</b> :		<b>Part Number</b> :	ECN30
<b>This Issue</b> :	01/05/2008	<b>Drawing Number</b> :	ECN1022
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	
<b>Previous Run</b> :	38917	<b>Material</b> :	
	<b>Type</b> :	<b>Due Date</b> :	01/05/2008
	MACHINED PARTS	<b>Qty:</b>	1
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :			

## **Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATE PAPERWORK:

D206559011

B 32977 (X)  
B 34288 8x  
B 37535 6x

ADD IIN+ ICA + MDL TO KITS

PER ECN1022

CHANGE LABELS TO NEW CHANGE NUMBER

CHG006

RETURN TO STOCK

8/5/5 SLP L5X

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/06 JF

Job Completion



MUF 08/05/05

